

Date: Friday, 9/21/2007 12:59:38 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, OUTBOARD, RH, 206
Job Number : 34780	
Estimate Number : 10523	
P.O. Number : N/A	Part Number : D26652
This Issue : 9/21/2007 S.O. No. : N/A	Drawing Number : D2665 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 32623	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 10/10/2007 Qty: 12 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: 00.11.01 Removed P/O for Powder Coat - in house process EC	
Est Rev:D As per Rev D 07-03-19 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

Batch B25349

NO MORE IN THE COMPUTER

JML 07/10/01 (12)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Program batch number

2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

SC 07.10.02

(12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SC 07.10.02 JML 07/10/03

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SC 07.10.02 JML 07/10/03

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.B. 07/20/04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 07/18/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 12:59:38 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 34780

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



12X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

07/10/05

7.0

POWDER COATING

POWDER COATING



M105068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MS 07-10-05

12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EF 07/10/05 12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EF 07/10/05 12

10.0

QC21

FINAL INSPECTION/W/O RELEASE



12

Comment: FINAL INSPECTION/W/O RELEASE

07/10/05

Job Completion



U 87-02-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>34780</b>
<b>Description: 206 Saddle, Outboard, Right side</b>	<b>Part Number:</b>	<b>D2665-2</b>
<b>Inspection Dwg: D2665 Rev. D</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.127	0.127	0.126		
B	0.100	0.140		0.123	0.120	0.121	0.122		
C	1.125	1.145		1.136	1.137	1.135	1.135		
D	0.615	0.685		0.678	0.680	0.680	0.680		
E	0.240	0.260		0.253	0.253	0.253	0.253		
F	1.313	1.343		1.329	1.328	1.328	1.328		
G	0.210	0.230		0.225	0.225	0.225	0.221		
H	0.100	0.180		0.141	0.141	0.140	0.141		
I	2.470	2.510		2.493	2.493	2.493	2.493		
J	1.565	1.585		1.573	1.574	1.573	1.573		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		1.000	1.000	0.999	0.999		
N	0.510	0.515		0.513	.513	.513	.513		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.320	0.320	0.320	0.320		
T	2.495	2.505		2.506	2.499	2.500	2.499		
U	1.357	1.367		1.360	1.360	1.360	1.360		
V	0.787	0.807		0.794	0.795	0.795	0.796		
W	0.540	0.560		0.550	0.551	0.550	0.550		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		0.258	0.259	0.258	0.258		
Z	0.912	0.932		0.925	0.924	0.923	0.924		
AA	0.490	0.510		0.500	0.501	0.501	0.501		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	/ SL
Date:	07/10/03

Audited by:	S.F
Date:	07/10/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>34780</b>
<b>Description: 206 Saddle, Outboard, Right side</b>	<b>Part Number:</b>	<b>D2665-2</b>
<b>Inspection Dwg: D2665 Rev. D</b>		<b>Page 1 of 1</b>

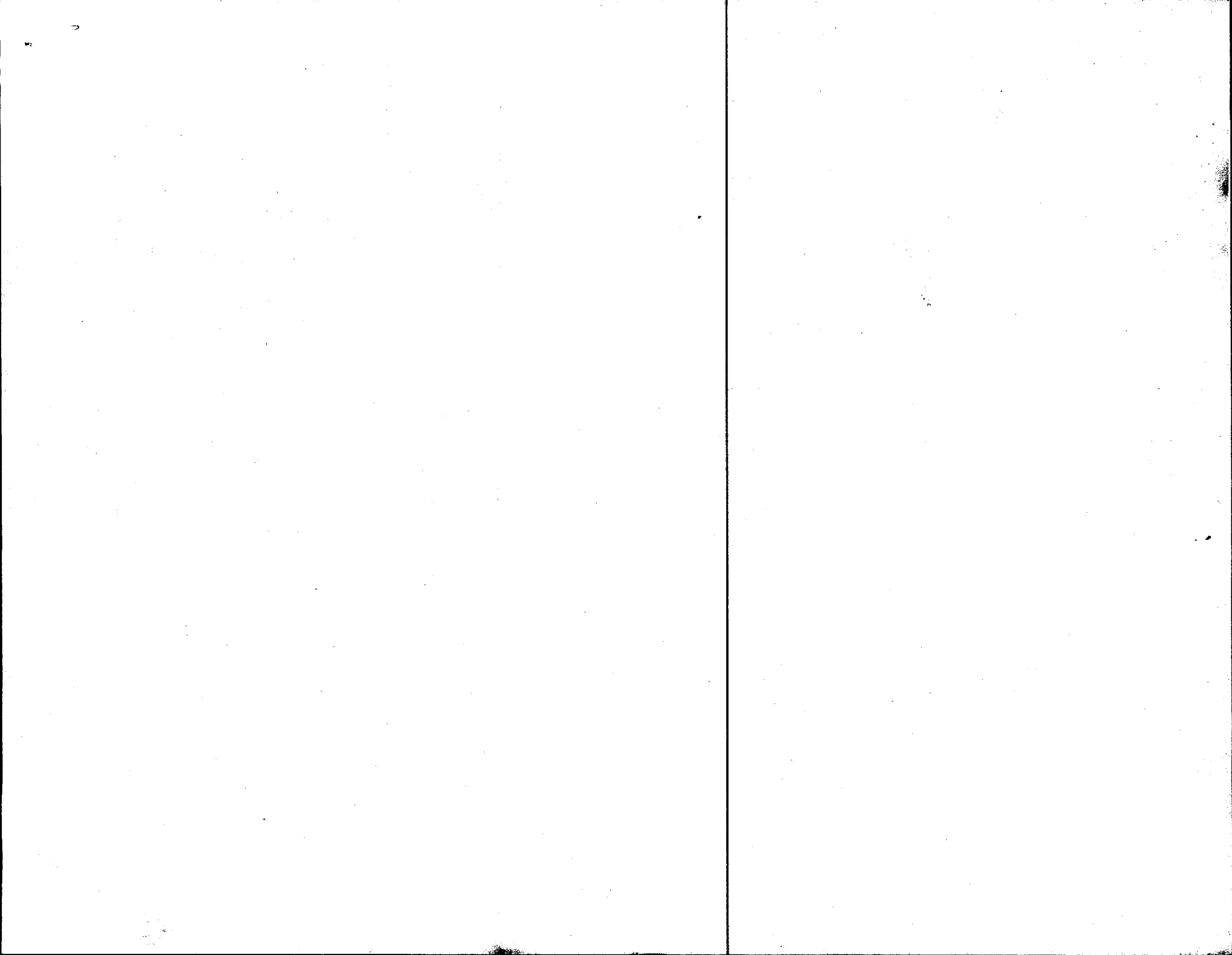
Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.127	0.127	.127		
B	0.100	0.140		0.124	0.122	0.122	.122		
C	1.125	1.145		1.135	1.135	1.138	1.138		
D	0.615	0.685		0.680	0.680	0.682	.682		
E	0.240	0.260		0.255	0.253	0.253	.253		
F	1.313	1.343		1.330	1.331	1.331	1.331		
G	0.210	0.230		0.225	0.225	0.225	.225		
H	0.100	0.180		0.140	0.140	0.140	.140		
I	2.470	2.510		2.494	2.495	2.494	2.494		
J	1.565	1.585		1.573	1.571	1.576	1.576		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		0.116	.116	.116	.116		
M	0.990	1.010		0.998	.998	.998	.998		
N	0.510	0.515		.513	.513	.513	.513		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	.314	.314	.314		
S	0.315	0.322		0.320	0.320	0.320	.320		
T	2.495	2.505		2.499	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.795	0.794	0.794	.794		
W	0.540	0.560		0.548	0.549	0.548	.548		
X	1.674	1.684		1.676	1.676	1.676	1.676		
Y	0.257	0.262		0.259	0.258	0.259	.258		
Z	0.912	0.932		0.924	0.923	0.923	.923		
AA	0.490	0.510		0.500	.500	.500	.500		
AB	0.178	0.198		0.188	0.188	0.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: <i>02.10.08</i>	Date: <i>02/10/01</i>

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: <i>02.10.08</i>	Date: <i>02/10/01</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34780
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2665-2
<b>Inspection Dwg:</b> D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.127	.127	.127	.127		
B	0.100	0.140		.122	.122	.122	.122		
C	1.125	1.145		1.138	1.138	1.138	1.138		
D	0.615	0.685		.682	.682	.682	.682		
E	0.240	0.260		.253	.253	.253	.253		
F	1.313	1.343		1.331	1.331	1.331	1.331		
G	0.210	0.230		.225	.225	.225	.225		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.494	2.494	2.494	2.494		
J	1.565	1.585		1.576	1.576	1.576	1.576		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		.998	.998	.998	.998		
N	0.510	0.515		.513	.513	.513	.513		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.320	.320	.320	.320		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.794	.794	.794	.794		
W	0.540	0.560		.548	.548	.548	.548		
X	1.674	1.684		1.676	1.676	1.676	1.676		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.923	.923	.923	.923		
AA	0.490	0.510		.500	.500	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	RF / JLM
Date:	07.10.04

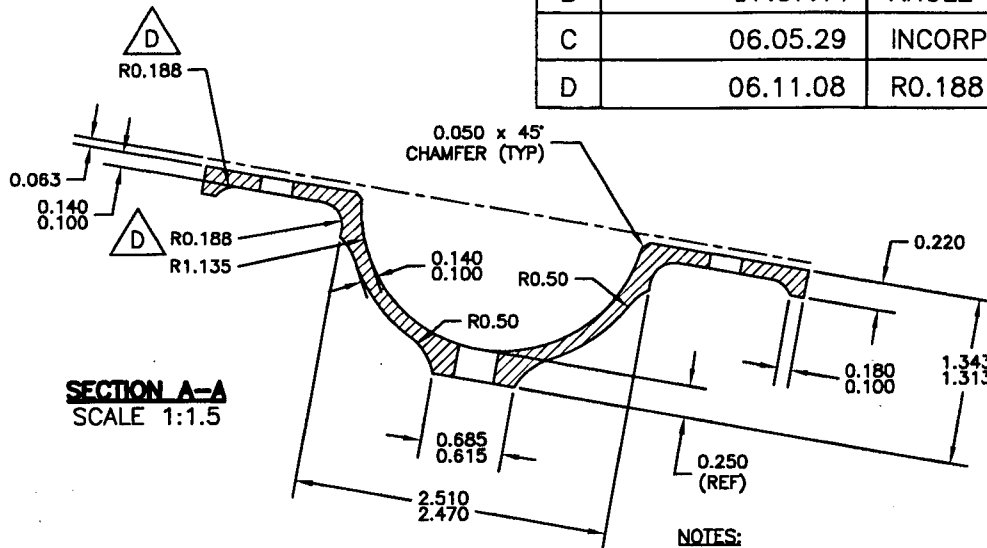
Audited by:	J.P.
Date:	07/10/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
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F	07.03.21	Revised per drawing revision D	KJ/JLM	



**DART**

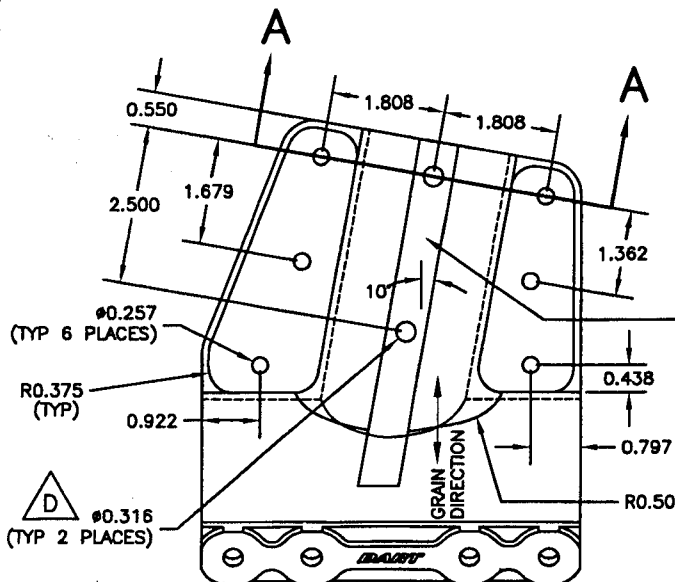
DESIGN <b>AH</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>AH</b>	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD OUTSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	



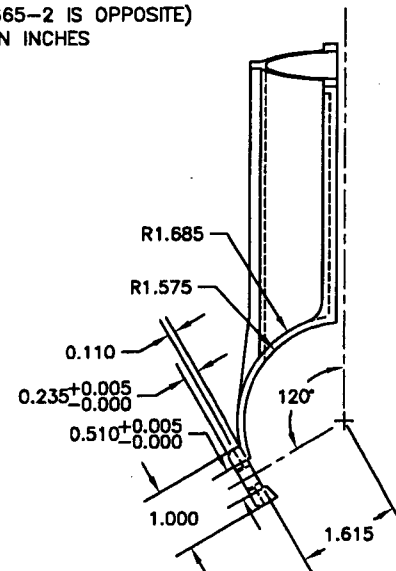
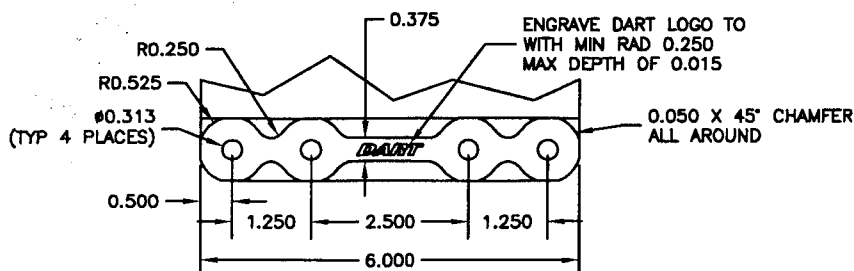
RELEASED  
07-02-12 **AH**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010



SHOP COPY  
RETURN TO  
ENGINEERING

**D2665-1 SADDLE FWD OUTSIDE HIGH**

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER  
34780

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